MULTI-FORM DIE BASE WITH ROTATABLE ANVILS HAVING ALTERNATIVE FORMING SURFACES

BACKGROUND OF THE INVENTION

1. Field of the Invention:

This invention relates generally to an apparatus and method for bending and forming sheet material such as sheet metal, plate steel and the like. More particularly, the present invention relates to a method and apparatus for enhancing the capability of the lower dies used in press brakes in which performance of multiple forming operations with different gauges of sheet material can be achieved without the need of changing to completely different lower dies. Specifically, the apparatus for bending and forming sheet material of the instant invention includes a die base, mobile carrier shoes, a plurality of spacer bars, and a pair of rotatable anvils having alternative forming surfaces.

2. Description of the Prior Art:

As is generally well-known, press brakes are equipped with a lower press member and an upper press member which are movable

relative toward and away from each other. Typically, the lower press member is stationary and the upper press member is reciprocatingly movable toward and away from the lower press member. The upper press member includes commonly a male forming tool (upper die or punch) having a bottom workpiece-deforming surface. The lower press member includes commonly an appropriately shaped lower die having an upper surface vertically aligned with the workpiece-deforming surface of the upper die. When the upper and lower dies are moved toward each other with a workpiece to be formed held over the lower die, the upper die descends into the workpiece and presses it into the lower die so as to deform the workpiece to a desired bent shape. However, it should be understood that the upper press member could be stationary and the lower press member is movable.

It is also generally known that the specific size and shape of the openings used in the lower dies are dependent upon the gauge of the material to be formed as well as the desired shape to be formed. For example, in many cases, the opening in the lower die is similar to the shape of the desired finished bend in the formed material. These openings in the lower dies must have the correct distance across the forming points (contact-forming surfaces) and have a sufficient depth therein so as to allow the required penetration of the material being formed into the lower dies and

down to the point for achieving the desired angle of bend in the material.

Further, the side surfaces and the bottom surface of the lower dies must have sufficient strength for withstanding the pressure transferred from the material being formed so as to prevent their flexing and/or splitting. The upper two points (inside edges) of the lower die are the only points of contact or forming surfaces since the material being formed never actually engages with the bottommost area of the lower die. This type of bending operation is sometimes referred to as an "air" bend or "air forming" method. The finished shape of the material is determined by the actual shape of the upper die (punch) and the depth of penetration of the material being formed into the lower die, as the material will then spring back to its finished shape.

One of the major problems encountered heretofore with the prior art press brake dies arises from the fact that it is often necessary to interchange upper and lower dies having different radius of curvatures and different distances therebetween in order to be able to bend and form the material into a desired configuration. While the upper die (punch) may be used for several bending operations for different gauges of materials, this is generally not the case with respect to the lower die having a

single-forming capability. Specifically, each gauge or shape of material being formed requires in many cases a separate and different appropriately-sized lower die to be substituted. Since these lower dies are manufactured conventionally from hard tool steel or similar material, they are generally quite large and heavy and are expensive to machine. Thus, these large and heavy lower dies must be unbolted and removed from the lower press member and new lower dies must be installed into the lower press member and then re-bolted. This operation is a considerable hindrance to the metal-forming industry in general since it causes a significant amount of downtime and expensive labor cost in exchanging of the lower dies to and from the press brakes due to their size and weight.

Another associated problem is that these lower dies require storage space for the ones not currently being used so that they can be re-used for future bending operations. This has resulted in a large number of different lower dies being stored for long periods of time at relatively high cost. In addition, there is suffered the disadvantages of having the unnecessary expense in the number of lower dies required to be purchased and of potential business opportunities being lost due to the unavailability of the appropriate lower die.

Accordingly, there exists a need for solving the above-mentioned problems of the prior art press brake dies. It therefore would be desirable to provide a method and apparatus for enhancing the capability of the lower dies in which performance of multiple forming operations with different gauges of sheet material can be achieved without the need of changing to completely different lower dies. It would also be expedient that the apparatus used in press brakes include a multi-form die base with rotatable anvils having alternative forming surfaces. The anvils are significantly smaller and lighter than the conventional lower dies and thus can be removed and installed in substantially less time.

A prior art search directed to the subject matter of this application in the U. S. Patent and Trademark Office revealed the following Letters Patent and application:

3,975,721	5,116,450
4,403,495	5,253,502
4,774,994	6,178,799
4,967,585	

In addition to the above issued prior art patents, there were also found published patent application No. 2001/0009106 to

Gerritsen on published on July 26, 2001 and published application No. 2003/0033846 to Runk et al. published on February 20, 2003.

In U. S. Patent No. 6,178,799 to Miller et al. issued on January 30, 2001,there is disclosed a forming press for shaping angle-section workpieces which includes an upper die shoe and a lower die shoe. The upper die shoe has affixed to it a pair of guides and a forming die secured therebetween by sliding the forming die between the guides so that the keys ride in the keyways. The lower die shoe includes a pair of cam blocks and a pair of main body members disposed movably between the cam blocks. The horizontal portions of the main body members support a pair of spacers. Further, the lower die shoe includes a pair of forming die inserts secured to the spacers by keys riding in the keyways.

In U. S. Patent No. 5,116,450 to Spoo et al. issued on May 26, 1992, there is taught a single die in which includes a mold base section and a mold insert section. The mold insert section is received in a channel portion so as to be removably connected to the mold base section by means of bolts and threaded holes. The die further includes a mold base section and a mold insert section which is received in a channel portion so as to be removably connected to the mold base section by means of bolts and threaded holes. A pair of clamp plates is provided for clamping the die

therebetween. The mold insert sections can be disconnected from their corresponding mold base sections by removing the bolts. Then, new mold insert sections defining a different shaped or sized mold cavity can be connected to the respective mold base sections.

In U.S. Patent No. 4,967,585 to Grimaldo issued on November 6, 1990, there is taught a bending die and ram assembly for use in a tube bending machine which includes a bending die having a convexly curved die face for bending engagement with a metal tube supported by a pair of backshoe dies mounted on an outwardly pivoting pair of back gates. The ram assembly utilizes retractor hooks which cooperate with lugs projecting from the underside of the bending die to permit the die to be attached and detached from the ram assembly in a drop-in, lift-out manner without tools. As a result, multiple bending dies of different sizes can be interchanged without requiring tools to the front of the pusher block.

In U. S. Patent No. 3,965,721 to Roch issued on June 29, 1976, there is disclosed a die holder frame which is received in a die bed of a press brake. A die holder bar is mounted to the frame and is supported on a plurality of adjustable wedges. The forming die is mounted in the die holder bar. The wedges are individually adjustable to provide a crown along the length of the die holder

bar and are adjustable as a group to provide various desired heights of the die bar holder.

The remaining patents, listed above but not specifically discussed, are deemed to be only of general interest and show the state of the art in forming press apparatuses for bending and forming of metal workpieces utilizing a first forming die and a second forming die being movable toward and away from the first forming die.

None of the prior art discussed above disclosed an apparatus for bending and forming sheet material like that of the present invention which includes a die base, mobile carrier shoes, a plurality of spacer bars, and a pair of rotatable anvils having alternative forming surfaces.

SUMMARY OF THE INVENTION

Accordingly, it is a general object of the present invention to provide an improved apparatus and method for bending and forming sheet material for use in a press brake which overcomes all of the problems encountered in the prior art.

It is an object of the present invention to a method and apparatus for enhancing the capability of the lower dies in which performance of multiple forming operations with different gauges of sheet material can be achieved without the need of changing to completely different lower dies.

It is another object of the present invention to provide an improved apparatus and method used in press brakes which includes a multi-form die base with rotatable anvils having alternative forming surfaces.

It is still another object of the present invention to provide an improved apparatus used in press brakes which includes a die base, mobile carrier shoes, a plurality of spacer bars, and a pair of rotatable anvils having alternative forming surfaces.

In a preferred embodiment of the present invention, there is provided an apparatus used in press brakes having a lower press member and an upper press member which are movable relative toward and away from each other for bending and forming sheet materials. The lower press member includes a die base formed of a generally U-shaped configuration and having a first recess and a second recess disposed opposite to the first recess. First and second mobile carrier shoes are disposed in a corresponding one of the opposed

first and second recesses. A plurality of first and second movable spacer bars is also disposed in a corresponding one of the opposed first and second recesses. A pair of anvils is disposed in a corresponding one of the first and second mobile carrier shoes.

Each one of said pair of anvils is formed of a rectangular shape and has four corners each provided with a separate and distinct radius of curvature so as to define four alternative forming surfaces. Each one of the anvils is initially positioned so that a first one of the four corners having the same radius of curvature are on top and facing inwardly toward the other corresponding to a first one of the four alternative forming surfaces and forming a first die-size opening therebetween used for bending and forming a material of a predetermined gauge.

Each one of the anvils is selectively rotatable to second through fourth positions so that second through fourth ones of the four corners having the same radius of curvatures are on top and facing inwardly toward the other corresponding to second through fourth ones of the four alternative forming surfaces and forming second through fourth die-size openings therebetween used for bending and forming a material of different predetermined gauges.

BRIEF DESCRIPTION OF THE DRAWINGS

These and other objects and advantages of the present invention will become more fully apparent from the following detailed description when read in conjunction with the accompanying drawings with like reference numerals indicating corresponding parts throughout, wherein:

Figure 1 is a simplified, schematic side view of a prior art press brake consisting of an upper press member and a lower press member;

Figure 2 is a cross-sectional view of a lower die base, constructed in accordance with the principles of the present invention and illustrating the various components in their assembled condition;

Figure 3 is a cross-sectional view of the die base assembly of Figure 2, but with the anvils rotated to a second position of the alternative forming surfaces;

Figure 4 is a cross-sectional view of the die base assembly of Figure 2, but with the anvils rotated to a third position of the alternative forming surfaces;

Figure 5 is a cross-sectional view of the die base assembly of Figure 2, but with the anvils rotated to a fourth position of the alternative forming surfaces;

Figure 6 is a cross-sectional view of the die base assembly of Figure 2, but with one of the removable spacer bars on each side being moved to the outside walls of the die base;

Figure 7 is a cross-sectional view of the die base assembly of Figure 2, but with all of the removable spacer bars on each side being moved to the outside walls of the die base;

Figure 8 is a side view of the lower die base of the present invention, taken along the line 8-8 of Figure 2;

Figure 9 is a side view of one of the plurality of spacer bars of the present invention, taken along the lines 9-9 of Figure 2;

Figure 10 is an exploded, perspective view of the lower die base of Figure 3;

Figure 11 is a side view of die base assembly of the present invention for use as a three-high die for performing a hemming operation on a sheet material; and

Figure 12 is a side view of an alternate embodiment of the present invention, illustrating enlarged anvils.

DESCRIPTION OF THE PREFERRED EMBODIMENTS

It is to be distinctly understood at the outset that the present invention shown in the drawings and described in detail in conjunction with the preferred embodiments is not intended to serve as a limitation upon the scope or teachings thereof, but is to be considered merely as an exemplification of the principles of the present invention.

Referring now in detail to the drawings, there is illustrated in Figure 1 schematic side view of a prior art press brake **10** consisting of an upper press member **12** and a lower press member **14**. The upper press member **12** includes an upper table **16** which has affixed thereto a male forming tool **18** (upper die or punch) having a bottom workpiece-deforming surface **20**. The upper table has a slot

into which is received a tang **19** of the male forming tool **18**. The lower press member **14** includes a lower table or press bed **22** which has affixed thereto as appropriately shaped lower die **24** having a V-shaped notch **26** vertically aligned with the workpiece-deforming surface **20** of the upper die **18**. The lower table **22** has a slot into which is received a tang **23** of the lower die **24**. The upper table **16** is further suitable connected to an actuator or ram **27** that is operable to extend the upper press member **12** toward the lower press member **14** for performing a forming operation on a workpiece **W** held therebetween and to retract the upper press member away from the lower press member when the forming operation has been completed.

Due to the particular size and shape of the V-shaped notch **26**, this conventional lower die **24** can be only used for a single forming operation on a material of a predetermined gauge to be formed into a desired shape. Thus, as previously pointed out, the lower die **24** must removed and replaced with a separate different, appropriately-sized lower die in order to effect different bending operations which is a laborious and time-consuming task. Therefore, a main purpose of the present invention is to replace the conventional lower die having a single-forming capability of the prior art with a new and improved apparatus adapted for use in press brakes for bending and forming sheet material which allows the performance of many different bending operations without the

need for changing to a completely different lower die. The instant invention provides for the capability of forming various shapes and bends in different gauges of materials with minimal disruption on the forming operation.

With particular reference to Figure 2, there is shown a cross-sectional view of a lower press member **28**, constructed in accordance with the principles of the present invention and illustrating the various components thereof in their assembled condition. Figure 8 is a side view of the lower press member **28**, taken along the lines 8-8 of Figure 2. Figure 10 is an exploded, perspective view of the lower press member of Figure 2.

In order to overcome these problems associated with the conventional lower die **24** in the press brake **10** of Figure 1, the inventor of the present invention has developed an improved apparatus for bending and forming sheet material which includes the lower press member **28** comprised of a lower brake press bed **29** and a die base assembly **32**. The lower brake press bed **29** has a downwardly-extending slot into which a tang **34** of the die base assembly **32** is received. The die base assembly **32** also has a downwardly-extending slot into which a tang of the prior art press brake die can be received. The die base assembly **32** is fixedly secured to the lower brake press bed **29** in a conventional manner by

the use of setscrews (not shown) spaced along its length thereof. When the die base assembly **32** is used to hold a prior art press brake die, threaded screws **38** are provided which are threaded into corresponding bores **40** and extend into the adapter slot **36** so as to abut against one side of the tang of the prior art die for retaining the same.

The die base assembly **32** of the present invention includes a die base **42** of a generally U-shaped configuration having a first recess **44a** and a second recess **44b** disposed opposite to the first recess. Each of the first and second recesses has affixed therein a corresponding one of mobile carrier shoes **47a, 47b.** The first recess **44a** has also affixed therein a plurality of removable spacer bars **50a** through **50e** all located between the inside wall **53a** of the die base **42** and the carrier shoe **47a**. Similarly, the second recess **44b** has also affixed therein a plurality of removable spacer bars **52a** through **52e** all located between the inside wall **53b** of the die base **42** and the carrier shoe **47b**. It will be noted that the spacer bars **50a-50e** and **52a-52e** are made of different thickness. For example, the spacer bars **50a, 50e** and **52a, 52e** each has a thickness of one-fourth (.250) of an inch; the spacer bars **50b, 50c** and **52b, 52c** each has a thickness of one-sixteenth (.062) of an inch; and the spacer bars **50d, 52d** each has a thickness of one-eighth (.125) of an inch.

Each of the mobile carrier shoes **47a, 47b** is of L-shaped configuration and has affixed therein a corresponding one of the pair of rectangularly-shaped, rotatable anvils **54a, 54b**. It can be seen that each of the four corners **56a** through **56d** on each anvil **54a, 54b** is provided with a separate and distinct radius of curvature so as to define four alternative forming surfaces. For instance, the corners **56a** are fabricated with a one-fourth (.250) inch radius of curvature; the corners **56b** are provided with a one-eighth (.125) inch radius of curvature; the corners 5**6c** are fabricated with a one-sixteenth (.062) inch radius of curvature; and the corners **56d** are provided with a one thirty-secondth (.031) inch radius of curvature.

As shown in Figure 2, each of the pair of rotatable anvils **54a, 54b** is positioned so that the corresponding corners **56a**, are on top and facing inwardly and opposite each other for defining a first position of the four alternative forming surfaces. In this first position, with the same radii of curvature on the top corners and facing inwardly toward each other there is provided a downwardly-extending gap or opening **58** of one-eighth inch between the pair of anvils **54a, 54b** defining one die-size opening for the bending and forming of a material of a predetermined gauge. When the pair of anvils is used in conjunction with an associated male

forming tool or punch, such as shown in Figure 1, a single forming operation is achieved.

Each of the anvils **54a, 54b** is further provided with central internally threaded bores **60** extending horizontally therethrough. Each of the mobile carrier shoes **46a, 46b** is provided with corresponding bores **62** aligned laterally with the respective bores **60**. Each of the plurality of spacer bars **50a-50e** and **52a-52e** are provided with inverted U-shaped notches **64a-64c** which are used to facilitate their ready removal and replacement, as will be explained hereinbelow. Each integral arm **66** of the die base **42** is provided with bores **68** disposed concentrically and aligned laterally with the notches **64a-64c** and the bores **62,60**. The bores **68** extends from outside wall **70a, 70b** of the die base **42** through to its inside walls **53a, 53b**.

The spacer bars, mobile carrier shoes, and rotatable anvils are held against the respective inside walls **53a, 53b** of the die base **42** by a plurality of opposed bolts **74**. Each of the plurality of bolts has a shaft **76** and a small threaded portion **78**. The bolts extend through the respective bores **68** in the die base, through the notches **64a-64c** in the spacer bars, and through the bores **62** in the mobile carrier shoes, and are threaded into the threaded bores 60 on the pair of anvils via the threaded portions **78**.

In order to change the pair of rotatable anvils **54a, 54b** of Figure 2 from the first position of the four alternative forming surfaces, the bolts **74** are initially loosened from the anvils and the pair of anvils are then rotated or inverted 180 degrees about the horizontal or x-axis so that the corners **56c** are now on top and facing inwardly toward each other for defining a second position of the four alternative forming faces. This second position creates another die-size opening for bending and forming a material having another predetermined gauge of thickness. This second position is illustrated in Figure 3 of the drawings.

On the other hand, the pair of anvils in Figure 2 could be rotated 180 degrees about the vertical or y-axis so that the corners **56d** are now on top and facing inwardly toward each other for defining a third position of the four alternative forming surfaces. This third position creates still another die-size opening for bending and forming a material having another predetermined gauge of thickness. This third position is illustrated in Figure 4 of the drawings. Thereafter, the anvils can again be rotated 180 degrees about the x-axis so the corners **56b** are now on top and facing inwardly toward each other for defining a fourth position of the four alternative forming surfaces. This fourth position creates still yet another die-size opening for

bending and forming a material having another predetermined gauge of thickness. This fourth position is illustrated in Figure 5 of the drawings.

As a result, it can be seen that the anvils are selectively rotatable so to provide the first through fourth positions of the four alternative forming surfaces. These anvils have a width dimension of about one-half inch; a height dimension of about one and one-fourth inch; and a length of about twenty-five inches. Since these anvils are substantially smaller and lighter than the conventional lower dies, they can be rotated to the different positions in substantially less time, thereby reducing downtime and labor cost.

Referring again to Figure 2, the gap **58** between the pair of anvils is approximately one-eighth inch as stated above and defines a first die-size opening for the bending and forming of a material having a specific gauge. In order to accommodate other specific gauges of materials, the spacer bars **50a-50e** and **52a-52e** of varying thickness are appropriately transferred to opposed outside walls **70a, 70b** of the die base **42** in one-eighth inch increments so as to provide twelve additional separate and distinct, expanded die-size openings Therefore, there are provided thirteen positions per the first position of the four alternative forming surfaces.

Since the size of the gap between the pair of anvils after being rotated to the positions of Figures 3 through 5 can likewise be increased in one-eighth inch increments so as to provide twelve additional separate and distinct, expanded die-size openings for each corresponding second through fourth positions of the four alternative forming surfaces, there are provided thirty-nine more die-size openings. As a result, the rotatable anvils and removable spacer bars in the die base of the present invention allow a total of fifty-two separate and distinct, expanded die-size openings for accommodating fifty-two different bending and forming operations.

With reference still to Figure 2, the operation of moving the spacer bars **50a-50e** and **52a-52e** to provide the twelve additional die-size openings will now be explained. In order to obtain the second die-size opening, the bolts **74** on each side of the die base **42** are loosened so to cause the spacer bars to loosen to the point of being removable. Then, one of the spacer bars having the thickness of one-sixteenth of an inch, i.e., **50b** and **52b**, on each side of the carrier shoes are lifted up and removed therefrom. With the bolts being drawn outwardly to allow removal of the spacer bars, this creates a pocket between the heads of the bolts and the outside walls **70a, 70b** of the die base **42** in which is received the just removed spacer bar with its notches **64a-64c** resting on top of

the shaft **76** of the bolts. Next, the bolts are re-tightened with the removed spacer bar being installed adjacent to the outside walls for the die base. This causes the head of the bolts to press the spacer bars against the outside walls to draw the anvils outward, thereby increasing the one-eighth inch gap between the pair of anvils by one-eighth inch to create the second expanded die-size opening. This is illustrated in Figure 6 of the drawings.

This process is repeated continuously over and over in one-eighth increments until all of the spacer bars **50a-50e** and **52a-52e** have been transferred to be adjacent the outside walls of the die base. This is depicted in Figure 7 of the drawings. Consequently, this process has provided the twelve additional expanded die-size openings for the first position of the four alternative forming surfaces due to the outward movement of the opposed anvils. It should be apparent to those skilled in the art that this process may now be reversed by moving the spacer bars in one-eighth inch increments back to their original positions for contracting the die-size openings until the first position shown in Figure 2 is reached again. Moreover, this process can be likewise performed on the spacer bars in the second through fourth positions of the forming surfaces in Figures 3-5, thereby realizing the total fifty-two different forming operations.

In Figure 9, there is illustrated a side view of one of the spacer bars, i.e., **50a** taken along the line 9-9 of Figure 2. The spacer bar is generally of an elongated, rectangular shape having a height dimension of slightly less than one and one-fourth inches and length dimension of about twenty-five inches. The plurality of inverted U-shaped notches **64a-64a** formed in the flat surface **80** are contoured and dimensioned so that the arch-shaped portion **65** are adapted to fit over and rest on top of the shaft portion **76** of the bolts. These notches facilitate the easy and quick removal and replacement of the spacer bars by simply lifting-up for removal and dropping-in place for replacement. While the spacer bars are depicted as being substantially flush with the top surfaces of the die base, carrier shoes, and anvils, they are preferable designed to be slightly shorter in height so as to avoid any potential interference with the material to be formed as it is slid across the top surfaces of the die base, carrier shoes, and anvils.

Although it is anticipated that many alternate uses of the present invention shown in Figures 2-10 will be employed, it is envisioned that the preferred embodiment herein just described has particular application for use in press brakes for bending and forming of sheet material, such as sheet metal, plate sheet and the like having a thickness of up to .187 inch. When all of the spacer bars are transferred to be adjacent to the outside walls of the die

base as shown in Figure 6 and the pair of anvils are rotated to the position shown in Figure 4 where the corners **56d** are on top and facing inwardly toward each other the maximum die-size opening for creating 90 degree bends is equal to 1.625 inches as measured between the inside edges of the anvils (edge-to-edge). When all of the spacer bars are transferred to be adjacent to the outside walls of the die base as shown on Figure 6 and the pair of anvils are rotated to the position shown in Figure 2 where the corners **56a** (.250 radii of curvature) are on top and facing inwardly toward each other the maximum die-size opening for creating acute bends (i.e., 30 degrees to 88 degrees) is equal to 2.125 inches as measured between the centers of the radii of curvature (center-to-center). It should be understood by those skilled in the art that an associated upper table have a punch ranging from, but not limited to, "28 degrees" punch to "85 degrees" punch would be used with the associated anvils to perform the different forming operations.

In Figure 11, there is a side view of the die base assembly of the present invention for use with a punch in a C-N-C press brake type of design commonly referred as a "three-high die". The lower press member **128** is comprised of a lower press brake bed **129** and a die base assembly **132**. The die base assembly **132** includes a die base **142** for housing mobile carrier shoes **146a, 146b;** a plurality

of spacer bars **150a-150d** and **152a-152d**; and a pair of anvils **154a, 154b**. This is quite similar to the various components shown in Figure 4, except that one of the spacer bars on each side of the carrier shoes has been removed. The spacer bar (not shown) of one-eighth inch thickness has been moved to be adjacent to the outside walls (also not shown) of the die base. Thus, the gap **158** of .375 inch wide is provided between the anvils **154a, 154b** which is sufficiently large enough for receiving therein a male forming tool or punch **118**. It will be noted that a deep pocket **160** is provided which extends below the gap **158** to accommodate a longer first stroke of the punch. This deep pocket **160** is also used to hold the tang of the prior art press brake die.

The C-N-C press brake type of design provides a stroking capability of performing in sequence a short stroke first which performs an acute bend and a second longer stroke which squeezes the material being formed together or "closes hem". In operation, the first stroke is delivered to the material held over the anvils **154a, 154b** by the acute punch **118** with a ledge portion **120** machined formed therein. The acute punch will penetrate the gap **158** to the point of the acute bend in the material held per the angle formed in the acute punch. The bent material is then removed and repositioned in the die base so that the second stroke will close the acute bend in the material onto itself, as illustrated in

Figure 11, by using the ledge portion **120** of the acute punch **118**. It will be noted that the ledge portion traps the acute bend in the material **122** between the bottom surface of the ledge portion and the top surface of the anvil **154a** as the punch descends to the correct closing depth. The long stroke of the acute punch is designed into the C-N-C press brake.

In Figure 12, there is depicted a second embodiment of the present invention where the small anvils and carrier shoes in Figures 2-10 are replaced with a pair of enlarged anvils **254a, 254b**. The small anvils **54a, 54b** of Figures 2-10 have a width dimension of about .500 inch and a height dimension of about 1.188 inch. On the other hand, the enlarged anvils have a minimum width dimension of about .750 inch which is equal to the combined widths of the small anvil **54a** (**54b**) and the carrier shoe **46a** (**46b**). The height dimension of the enlarged anvils is equal to 1.625 inches which is the height of the carrier shoes **46a, 46b**. The enlarged anvils serve to increase the bending capability by accommodating the bending of materials having various gauges with different angles or special complex shapes/designs during the bending operations as specified by a user.

The forming surfaces of the enlarged anvils can be provided with one of a number of shapes or forms, such as indicated by the

dotted lines **200a-200h**, which otherwise may be impractical or impossible to machine. The increased width of the enlarged anvils permits increased machining capability since the carrier shoes **46a**, **46b** have been eliminated, thereby reducing limitations of machining a specific shape or form thereon. Further, the width size of the enlarged anvils may be increased or changed to have other dimensions as desired by the user.

From the foregoing detailed description, it can thus be seen that the present invention provides an improved apparatus used in press brakes having a lower press member and an upper press member which are movable relative toward and away from each other for bending and forming sheet materials. The apparatus includes a die base, first and second mobile carrier shoes, a plurality of spacer bars, and a pair of anvils. Each one of the pair of anvils is formed with four corners each having a separate and distinct radius of curvature so as to define four alternative forming surfaces. Each one of the anvils are selectively rotatable so that one of the four corners having the same radius of curvatures are on top and facing inwardly toward the other corresponding to first through fourth ones of the four alternative forming surfaces and forming first through fourth die-size openings therebetween used for bending and forming a material of different predetermined gauges. As a result, multiple bending operations with different gauges of

sheet material can be achieved without changing completely to a different lower die.

While there has been illustrated and described what is at present considered to be a preferred embodiment of the present invention, it will be understood by those skilled in the art that various changes and modifications may be made, and equivalents may be substituted for elements thereof without departing from the true scope of the invention. In addition, many modifications may be made to adapt a particular situation or material to the teachings of the invention without departing from the central scope thereof. Therefore, it is intended that this invention not be limited to the particular embodiment disclosed as the best mode contemplated for carrying out the invention, but that the invention will include all embodiments falling within the scope of the appended claims.